



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0113

Job Sheet 204982



Part No: 647.0113

Job Qty: 24 pcs

Part Name: Strut Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.0100 REV.B SHEET 4 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Waterjet - Flow - 1	24 pcs	2/14/20	2/14/20	0.01	0.99	Waterjet - Flow	OK 20/01/27
120	QC 2	24 pcs	2/14/20	2/14/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	OK 20/01/27
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

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130 QC 8	24 pcs	2/14/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS JAN 27 2020 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 4 - Anodize	24 pcs	2/14/20		ATG001-VC	2020-01-30
150 Packaging 2-1 - Receive - B4B	24 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	

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					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
160 QC 6	24 pcs	2/14/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
190 Packaging 3-1 - Stock - B4B	24 pcs	2/14/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
200 QC 21 - SA	24 pcs	2/14/20	0.00 0.00		QC 21 - SA - 21 ✓	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg Dwg Rev: <u>8</u> Prog Rev: <u>8</u> 2-Deburr if necessary						
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)						
130 - (QC8- Inspect parts - second check)						

DAS
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FEB 18 2020

DAS
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CCK089
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FEB 18 2020

140 - Issue P/O to ATG: 45741 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC6- All purchased or subcontracted products)
 190 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.125	2024-T3 .125 Sheet	7.6320 sf (.318 ea)	110-Waterjet - Flow - 1	<u>5018262</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.125	8	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Doubler	4.000Inches $\pm$ 0.030	4.030 3.970	<u>4.005</u>	
2	Strut Doubler	11.450Inches $\pm$ 0.030	11.480 11.420	<u>11.448</u>	
3	Strut Doubler	1.700Inches $\pm$ 0.030	1.730 1.670	<u>1.699</u>	

0.125 $\pm$ 0.0100.125 Plex 12/23/19 2:27 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S250979



Part: 647.0113

Job No: 204982

Serial No/Batch: S250979

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/27/20



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045741



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	205082	647.1812	647.1800 Rev NC	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	2/17/20	20 pcs	0 pcs	20 pcs	\$7.57/pcs	\$151.40
5	205404	D5582-1	D5582 Rev A	Aft Angle : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5582 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	2/10/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36
6	205408	D5589-1	D5589 Rev B	Gusset, Outboard LH : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5589 2- Prime Grey as per Dwg. QSI 005,4.2.1.3.2 Certification of Conformity is required.	Firmed	-	2/10/20	8 pcs	0 pcs	8 pcs	\$6.82/pcs	\$54.56
7	204677	RBW6405G00332-3G-11	RBW6405G00332-3G Rev 5	Pointer (Outsource process- Anodize per QSI017 4.1.10.1) -Issue PO STRIP and re-anodize -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	2/17/20	6 pcs	0 pcs	6 pcs	\$3.49/pcs	\$20.94



Dart Aerospace Ltd.
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PURCHASE ORDER **POHB045741**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045741
PO Date: 1/30/20
Due Date: 2/17/20
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2020-02-12

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206082	D5811-1	D3811 Rev C	Bushing : Various STC's ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR 1C OR II OR IIB CLASS 2 C OF C IS REQUIRED	Firmed X24	-	2/17/20	24 pcs	0 pcs	24 pcs	\$3.49/pcs	\$83.76
2	197463	RBE350A93-3501-20	RBE350A93-3501-20 Rev E	(Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3501-20 Rev. E -Certificate of Conformity is required	Firmed X15	-	2/17/20	15 pcs	0 pcs	15 pcs	\$3.49/pcs	\$52.35
3	203795	D5583-1	D5583 Rev A	Radius Block : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5583 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed X36	-	2/10/20	36 pcs	0 pcs	36 pcs	\$5.27/pcs	\$189.72

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PURCHASE ORDER

POHB045741



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	204978	647.0110	647.0100 Rev B	Roof Doubler : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	2/17/20	16 pcs	0 pcs	16 pcs	\$43.72/pcs	\$699.52
9	205406	D5585-1	D5585 Rev A	Stringer, LH Fwd : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5585 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed x8	-	2/17/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36
10	204982	647.0113	647.0100 Rev B	Strut Doubler : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed x24	-	2/17/20	24 pcs	0 pcs	24 pcs	\$12.47/pcs	\$299.28
11	205407	D5588-1	D5588 Rev A	Stringer, RH Aft : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5588 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed x8	-	2/17/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36

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FEB 14 2020

FEB 14 2020



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045741



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total: \$1,729.61												

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

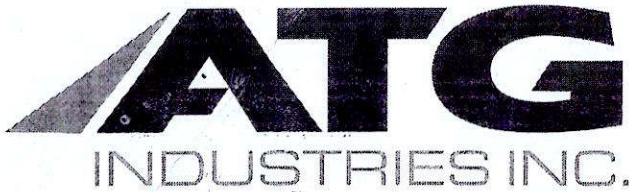
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/12/20 12:53 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919568

Date: 13-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

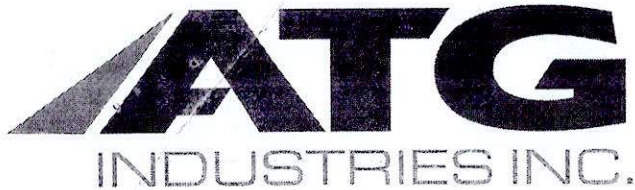
Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
24 ea	Part: 647.0113 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5225973 Job: 26888 PO: POHB045741	Rev: A Expiry Date: 05/30/2021 Line: 10	DAS 40 9-89
8 ea	Part: D5588-1 Stringer, RH Aft Hard Black Anodize per MIL-A-8625F, Type II, Class2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Batch/Lot#: 5225973 Job: 26889 PO: POHB045741	Rev: A Expiry Date: 09/30/2021 Line: 11	
8 ea	Part: D5589-1 Gusset, Outboard LH Hard Black Anodize per MIL-A-8625F, Type II, Class2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Batch/Lot#: 5225973 Job: 26884 PO: POHB045741	Rev: A Expiry Date: 09/30/2021 Line: 6	
CERTIFICATE OF CONFORMANCE A.T.G. Industries Inc. certifies that all items in this shipment conform to the requirements.		DART AEROSPACE LTD.	
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919568

Date: 13-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Date: <u>FEB 13 2020</u>	
	Certified Signature: <u></u>	
	Receiver Signature: _____	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919567

Date: 13-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
36 ea	Part: D5583-1 Radius Block Hard Black Anodize per MIL-A-8625F, Type II, Class2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Batch/Lot#: 5225973 Job: 26881 PO: POHB045741	Rev: A Expiry Date: 09/30/2021 Line: 3	
8 ea	Part: D5582-1 Aft Angle Hard Black Anodize per MIL-A-8625F, Type II, Class2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Batch/Lot#: 5225973 Job: 26883 PO: POHB045741	Rev: A Expiry Date: 09/30/2021 Line: 5	
8 ea	Part: D5585-1 Stringer, LH Aft Hard Black Anodize per MIL-A-8625F, Type II, Class2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Batch/Lot#: 5225973 Job: 26887 PO: POHB045741	Rev: A Expiry Date: 09/30/2021 Line: 8	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: FEB 13 2020		RECEIVED FEB 14 2020 DART AEROSPACE LTD.	
Made in Canada.			



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Pack List

Number: 919567

Date: 13-Feb-20

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Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Certified Signature: _____	
	Receiver Signature: _____	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		